


Work Order ID 82701

Thursday, April 05, 2012 8:11:49 AM

82701

Page 1

Item ID: DSK076 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: D2891-1 TURNING DETAIL
 Start Date: 4/5/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 4/20/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan:  Date: 2-04-5 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSK076	Rev A								

100
100
 Doosan
 Doosan Lathe
 DOOSAN LATHE
 Memo
 Turn blank for as per Folio FA046
 12/4/25 SD
 10 0

110
110
 QC
 Quality Control
 QC2- Inspect parts off machine FAI/FAIB
 Memo
 12/4/25 SD
 10 0

120
120
 QC
 Quality Control
 QC8- Inspect parts - second check
 Memo
 12-4-28 10 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and Stock in KanbanLocation: <u>CNC</u>								
140		0.00							
140	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

12/4/2012

12-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 05, 2012 8:11:55 AM

Page 1

Work Order ID: 82701

82701

Parent Item: DSK076

DSK076

Parent Item Name: D2891-1 TURNING DETAIL

Start Date: 4/5/2012

Required Date: 4/20/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-003

Manufactured

No

Each

16.0000

**

10

D6104-003

Round Billet, 17-4

12/4/25

Location

Loc Qty

Loc Code

MAT043

16

60943

3

81882

13

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries


DART AEROSPACE LTD		Work Order: 82701
Description: Turning Detail for D2891-1		Part Number: DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1


FIRST ARTICLE INSPECTION DIMENSION SHEET



☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279		2.279	2.279	2.279	2.279	2.279
B	3.702	3.722		3.719	3.714	3.714	3.714	3.714
C	2.564	2.584		2.573	2.574	2.575	2.575	2.575
D	0.718	0.738		.730	.730	.730	.730	.730
E	0.090	0.110		.101	.101	.101	.101	.101
F	2.464	2.484		2.473	2.471	2.475	2.475	2.475
G	2.029	2.049		2.040	2.040	2.040	2.040	2.040
H	2.964	2.984		2.973	2.974	2.975	2.975	2.975
I	0.913	0.933		.923	.923	.923	.923	.923
J	0.022	0.042		R.031	R.031	R.031	R.031	R.031
K	0.090	0.110		.098	.098	.098	.098	.098
L								
M								
N								
O								
P								

Measured by:  **Date:** 12/4/25

Audited by:  **Date:** 12.4.26

Prototype Approval:  **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM 	

DART AEROSPACE LTD		Work Order:	82701
Description: Turning Detail for D2891-1		Part Number:	DSK076
Inspection Dwg: DSK076		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
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Lathe Section								
A	2.274	2.279		2.279	2.278	2.279	2.279	2.279
B	3.702	3.722		3.714	3.712	3.715	3.712	3.713
C	2.564	2.584		2.575	2.575	2.575	2.575	2.575
D	0.718	0.738		.730	.730	.730	.730	.730
E	0.090	0.110		.100	.101	.101	.100	.101
F	2.464	2.484		2.475	2.475	2.475	2.475	2.475
G	2.029	2.049		2.040	2.040	2.040	2.040	2.040
H	2.964	2.984		2.975	2.975	2.975	2.975	2.975
I	0.913	0.933		.928	.928	.928	.928	.928
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110		.097	.099	.098	.098	.098
L								
M								
N								
O								
P								

Measured by: SA Date: 12/14/25

Audited by: [Signature] Date: 12.4.26

Prototype Approval: Date:

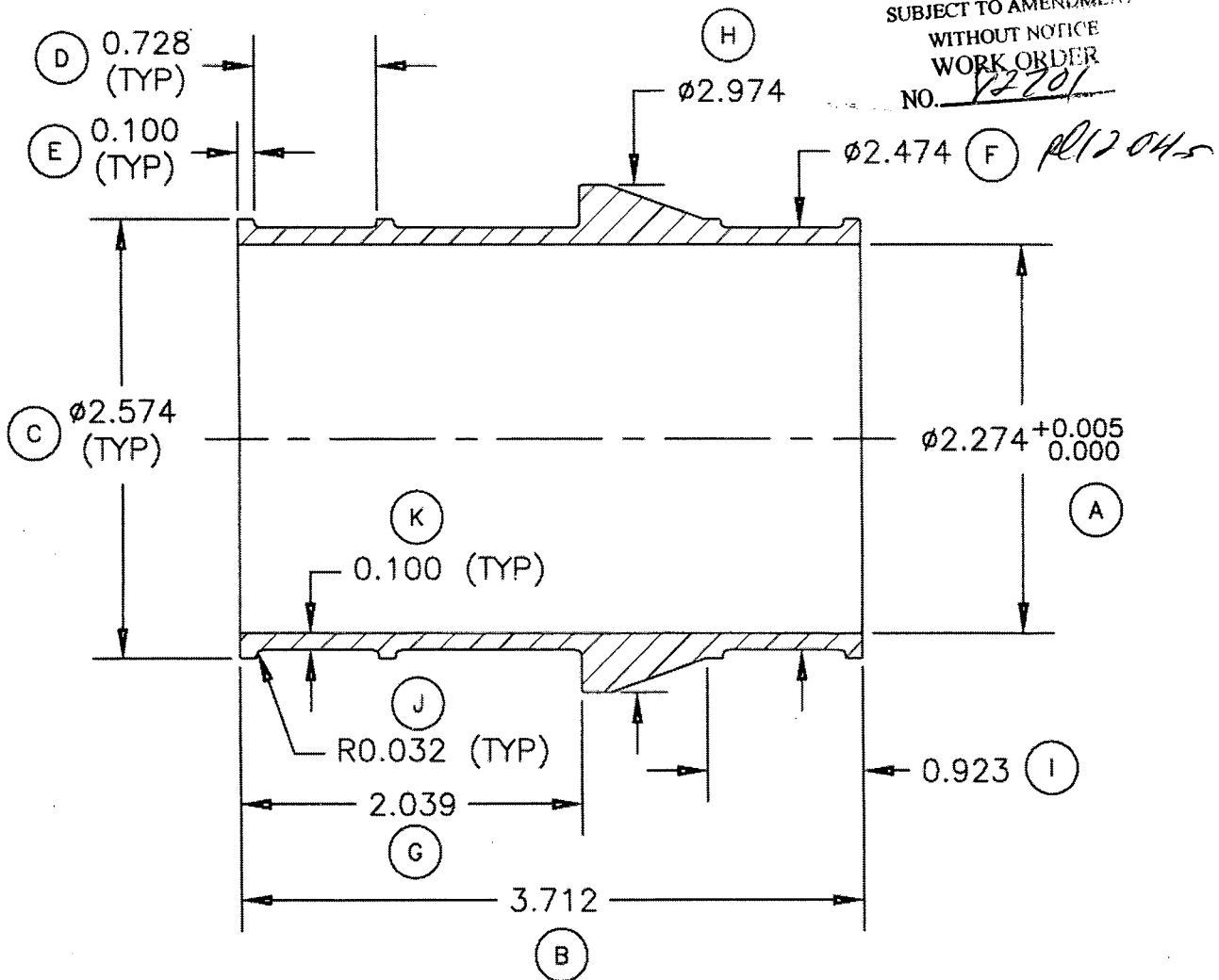
Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	[Signature]



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01 [Signature]

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. V2701



D2891-1 TURNING DETAIL

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